

**THE APPARATUS AND METHOD FOR ATTACHING
HEAT EXCHANGE UNIT AND VALVE TO THE BOTTOM OF
SELF-COOLING AND SELF-HEATING FOOD OR
BEVERAGE CONTAINERS**

Abstract of the Disclosure

5 A method of forming a flange in the bottom of a container by first removing a portion of the container bottom and then forming or swaying the material around the opening to form a flange extending away from the container bottom. A valve and valve cup assembly along with a heat exchange unit are positioned adjacent the flange and the combination is crimped to permanently affix the heat exchange unit to the bottom of the container.